Work Order I June-12-13 9:16:07			*102		Page 1						
Revision ID:	161-5	A	Accept	*N900	<b>040</b>	100	)* s	etup Stai Sto	ı u	S1*	
-, "\$	1/13	*49* *10*		Cust Item l Customer:	D:			240	r ^N	S2*	
	ocess Plan: MLT	Date: 13-06-14	Tooling: _ SPC (Y/N):		ate:		R	tun Sta Sto		R1* R2*	· · · · · · · · · · · · · · · · · · ·
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	- <del></del>
Draw Nbr	Revision Nbr										
D3461	Rev A										_ :
*1 \\ \C\C\C\C\Waterjet	FLOW WATER JET  Memo  1-Cut as per  Dwg Rev:_  Prog Rev:_  2-Deburr if	_A_	0.00				15	0		Ae 13/12	· <b>3</b> 0
110 *110* QC Quality Control	QC2- Inspect parts off n  Memo	nachine FAI/FAIB	0.00		X.		_15	<b>ə</b>	-	Ac 13.1	<i>Э</i> ∙30
120 *170* QC Quality Control	QC8- Inspect parts - sec Memo	ond check	0.00				(3)	14-01	-60	DAS 9 9-89	*

DQA:		Date:												
			•		WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_		AEROSPACE	
QA Closed:		Date:							W	ork Order up	odate only			
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS			
				_	Rework			Skid-tube Crosstube	Г	1	Water Jet	7 E	ngineering	
Part N	lo.				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.		Quality	
	<u> </u>			_	Use-as-is		Therr	noforming Finishing		Rec/Store/Packaging			Other	
NCR N	lo				Suspected Unapproved			Large Fab Composite			Supplier			
Root				Desci	ription of work order update		Initial	Action		Sign &				
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	,	QC Inspector	
Design														
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Handling/Pre														
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				···		FAI	ULT CA	TEGORY		<u></u> .	·			
Landii	ng Gear			_	General		,			-	_			
ĺ	Bendi	-		<u> </u>	Bend		Folio/F	Program		Outside Dim	ensions	Pré	essure/Forced	
		e Not Conce	ntric		BOM/Route	_	Grain			Over/Under	tolerance	Se	t-up	
		Cracks			Broken/Damage/Defect		Hardwa	ire .		Part Incorred	it [	Te	mperature/Cure	
		Crimp/Kink/Ripple/Wave			Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/Mi	ssing	\w	eld	
		Cuffs			Contamination	_	4	tions Incomplete/Unclear		Part Moved	L	wı	rong Stock Pulled	
	Crushing			<u> </u>	Countersink		1 1	gned/off center	L	Positioned V	Vrong	<del></del> ,		
	Heat Treat			<u> </u>	Cut Too Short		Mislabe			Power Loss/	Surge	Ot	her	
	Inspection Strip in Tube				Drawing		Misread	d						
		/Chatter			Drill Holes		Off-set							
		ng Sequence			Finish	Out of Calibration								
	Wave/Twist in Tube				Fit/Function		Out of	Sequence						

Work Orde June-12-13 9:10		2886		*102	2886*						Page 2
Item ID: Revision ID: Item Name:	D3461-5  Mounting Pla	ute		Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Stai Sto	I VI	S1* S2*
Start Date: Required Date:	6/11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12 *12		Cust Item I Customer:	D:				i W	. 12
Reference: Approvals:	Process Pl	an:	Date:			ate:		R	tun Sta		R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130* Small Fab Small Fab		Small Fab  Memo  Deburr parts	s per dwg D3461	0.00							
140 *140* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00	DAS 9 9-89						
150 <b>*150*</b> Packaging	·	Identify as per dwg & St  Memo	ock Location: WM	4.003 0.00 0.00				15	<b>4</b> _		M 14.01.00
Dooksaina			IN STEP CELL***								14.0100

\*\*\* STOCK IN STEP CELL\*\*\*

Packaging

DQA:		Dat	e:											
QA Closed:		Dat	e:		WORK ORDER NON-	-C(	ONFO	RMANCE / UPDATE	w	ork Order up	odate only	AEROSPACE		
Mark Orde	· ·	-·· -			DISPOSITION			AGAINS						
Work Orde	٠·				Daws at [	.			_	1	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			
Part N	No				Rework Scrap Use-as-is			Skid-tube Crosstube  Machining Small Fat  noforming Finishing		4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR N	No				Suspected Unapproved		men	Large Fab Composite	_	, Rec/Stoi	Supplier	- Other		
Root		1		Desc	ription of work order update	ı	nitial	Action		Sign &				
Cause	D	ate Ste	o Qty		or non-conformance	1	ief Eng			Date	Verification	QC Inspector		
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Offset/Setup					:									
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Unapproved														
						FA	ULT CA	TEGORY	•	<b>*</b>				
Landi	ng Gear				General									
	Ben	ding			Bend		Folio/F	Program	Г	Outside Dim	ensions	Pressure/Forced		
	Cen	tre Not Con	centric		BOM/Route		Grain			Over/Under	tolerance	Set-up		
	Crac	Centre Not Concentric Cracks			Broken/Damage/Defect	Г	Hardwa	are	Г	Part Incorred	ct [	Temperature/Cure		
	Crin	Crimp/Kink/Ripple/Wave			Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
	Cuff	Cuffs			Contamination		Instruct	tions Incomplete/Unclear	$\vdash$	Part Moved	Ī	Wrong Stock Pulled		
	Crushing				Countersink		Misalig	gned/off center	Г	Positioned V	Vrong <u>►</u>	_ `		
	Heat Treat				Cut Too Short	Γ	Mislabe			Power Loss/		Other		
	Inspection Strip in Tube				Drawing	Misread				_	_	— · · · · · · · · · · · · · · · · · · ·		
	Marks/Chatter			Drill Holes	Г	Off-set					· · · · · · · · · · · · · · · · · · ·			
	Turi	ning Sequer	ce		Finish		Out of	Calibration						
	Wav	/e/Twist in	Гubе		Fit/Function		Out of	Sequence						

Work Ord June-12-13 9:1		2886		*102	2886*							Page 3
Item ID: Revision ID:	D3461-5  Mounting Plat	0		Accept	*N900	<b>040</b>	100	<b>)</b> *	Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date Reference:	6/11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:					IV	.7/
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		nte:		1	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I 160 *160* QC	ID	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	·	Reject Number	Insp. Stamp
Quality Control		Memo						B	OH U	101/2 401	014	

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QA CIOSCU.		Date	· 					<del></del>		VV	ork Order up	date only		
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
				_	Rework			Skid-tube		]	Water Jet	$\neg$	Engineering	
Part N	lo.				Scrap			Machining	Crosstube Small Fab		Pro	d. Eng. Coor.	7	Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Store/Packaging			Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier		
Root		T	1	Desci	ription of work order update		nitial	Act	ion	Sign &				
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	Crimp/Kink/Ripple/Wave			-	Burrs	L	1	ion Incomplete/Un	•		Part Lost/Mi	· -	-	Veld
	Cuffs			<u> </u>	Contamination	-	1	ions Incomplete/U	Inclear		Part Moved	<u> </u>	\v	Vrong Stock Pulled
	Crushing				Countersink	$\overline{}$	1 .	ned/off center			Positioned V			
:	Heat Treat			<u> </u>	Cut Too Short	_	Mislabe				Power Loss/	Surge	C	Other
	Inspection Strip in Tube			$\vdash$	Drawing	-	Misread	d						
		/Chatter			Drill Holes	<u> </u>	Off-set							
		g Sequence			Finish	<u> </u>	1	Calibration						
	Wave/Twist in Tube				Fit/Function		Out of 9	Sequence						

Page 1

Work Order ID:

102886

Parent Item:

D3461-5

Parent Item Name:

Mounting Plate

**Start Date: 6/11/13** 

Required Date: 6/11/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV. A 05.12.13 NEW ISSUE EC

IPP Rev:B Now on Waterjet 06-11-24 JLM

•	HI KCV.D HOW	ni waterjet 00-1	1 2 1 31										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.000 6061-T6 Bar .187 x 4.00		Purchased	No			100	f	122.8400	0.367	4.6357890	5 /	le i	3.19.30
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT051		122.84							
				12323	79	22.84							
				12559	90	100			12	5590	<del></del>	5.6	ט

DQA:		_ Date:												
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QA Closed:		Date:				_				W	ork Order up	odate only		
Work Orde	r:				DISPOSITION				/PROCESS					
					Rework	1		Skid-tube	Crosstube	Г	]	Water Jet	Engineering	
Part N	io.				Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality	
		•			Use-as-is			noforming	Finishing			re/Packaging	Other	
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier		
Root	1			Desci	ription of work order update	Initial Action			ion	Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector	
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}	Bending				Bend	<u> </u>	1	rogram		_	Outside Dim	<b> </b>	Pressure/Forced	
-		ot Conce	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			<u></u>	Over/Under	<u> </u>	Set-up	
}	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorred	· -	Temperature/Cure	
1	Crimp/Kink/Ripple/Wave			<u> </u>	Burrs	<b>-</b>	1 '	on Incomplete/Un	•		Part Lost/Mi	· · ·	Weld	]
	Cuffs				Contamination	$\vdash$	1	ions Incomplete/U	Inclear	<u> </u>	Part Moved		Wrong Stock Pulled	·
	Crushing			<u> </u>	Countersink	_		ned/off center		-	Positioned V	_	<b>¬</b> .	
ŀ	Heat Treat Inspection Strip in Tube			<u> </u>	Cut Too Short	<u> </u>	Mislabe			Power Loss/Surge Other				
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	Marks/C			-	Drill Holes	$\vdash$	Off-set	7-1:la						
}		Sequence			Finish Fit /Function	$\vdash$	-	Calibration						$\dashv$
	Wave/Twist in Tube				Fit/Function	1	Out of 9	Sequence						

D3065-5DART AEROSPACE LTD	Work Order:	102886
Description: Mounting Plate	Part Number:	D3461-5
Inspection Dwg: D3461 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Measured by:	A	2	Audited by:	9 9-89	Prototype Approval:	N
Date:	131	12.30	Date:	14-01-03	Date:	N/

Rev	Date	Change	Revised by	Approved
Α	06.12.07	New Issue	KJ/JLM o	R
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PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. (TYP) R0.386 (TYP) 102886 ML3 13-06-14 Ø0.257 2.846 (TYP) R<sub>0.125</sub> 0.761 2.846 (TYP) D2622 0.761 EXTRUSION **PROFILE** -D2622 CHECKED 05 R<sub>0.125</sub> **EXTRUSION** .09.19 (TYP) PROFILE P .55 R8.0-05.09.19 1.121 0.893 R8.0 DRAWING NO. D3461 STEP MOUNTING NEW ISSUE DART .551 Ø0.257 (TYP) AEROSPACE I D3461-1 MOUNTING PLATE D3461-3 MOUNTING PLATE P: 11.50 PLATE D3461-1/-3 MOUNTING PLATE MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK (REF DART SPEC. M6061T6S.188) USA, 2) FINISH: NONE 3) ALL DIMENSIONS ARE IN INCHES SHEET 1 COPIED TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED RC. 우 2

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. Ø0.257 R<sub>0.125</sub> (TYP) (TYP) Ø0.257 R0.386 (TYP) R0.386 (TYP) (TYP) 0.586 2.715 2.715 R<sub>0.125</sub> D2622 EXTRUSION (TYP) 0.586 **PROFILE** D2622 **EXTRUSION PROFILE** 1.101 0.889 1.337 --1.337 D3461-5 MOUNTING PLATE D3461-7 MOUNTING PLATE 1111-50 

D3461-5/-7 MOUNTING PLATE

MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK (REF DART SPEC. M6061T6S.188)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED